

# Work Order ID 60087

June 24, 2010 9:12:54 AM



Page 1

Item ID: D3260-1

Accept



Setup Start



Revision ID:

Item Name: Spring

Stop



Start Date: 6/24/10

Start Qty: 4.00



Cust Item ID:

Required Date: 7/02/10

Req'd Qty: 4.00



Customer:

Reference:

Run

Start



Approvals: Process Plan: CX

Date: 10/6/24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3260

Rev A

100



Purchasing

PURCHASING

0.00

Memo

0.00

Purchasing

Issue P/O: 12149 [ ] Make as per Dwg D3260 [ ] Possible Supplier:  
Victory Spring [ ] Material release note is required

CX 10/6/24 10

110



Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

Packaging

Ensure Material Release Note is attached

10/6/24 (10)

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

Solution

(410)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 60087

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Start Date: 6/24/10

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Customer:

Reference:

Run

Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



Packaging

Identify as per dwg & Stock Location: 048

0.00

Memo

0.00

Packaging

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*Prof/h* (10)

*1007-07*  
*MF* 10-7-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

June 24, 2010 9:12:53 AM

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Work Order ID: 60087

Parent Item: D3260-1

Parent Item Name: Spring




Start Date: 6/24/10

Required Date: 7/02/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A1104.03.29 New issue KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3260-1P  Spring		Purchased	No			100	Each	0.0000	1	4		6/17/10	(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

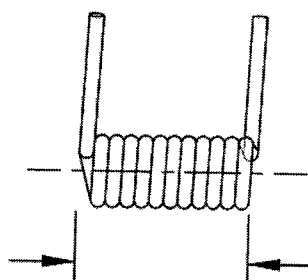
**NOTE:** Date & initial all entries



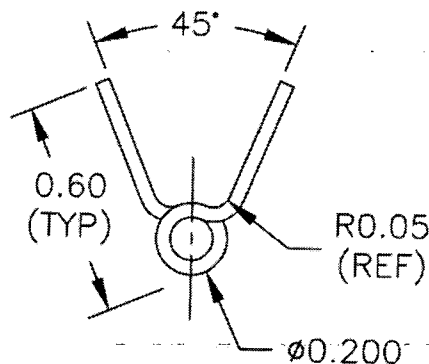
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3260	REV. A SHEET 1 OF 1
DATE 04.02.27		TITLE SPRING	SCALE 2:1
A	04.02.27	NEW ISSUE	

RELEASED  
04.04.07

## SPECIFICATION CONTROL DRAWING



Ø0.040  
12 COIL  
(REF 0.480)



### D3260-1 SPRING

C210/6124

W10'60087

#### D3260-1 NOTES:

- 1) MATERIAL: AISI-302-SS-SPRING WIRE Ø0.040 PER ASTM A313  
(MIN TENSILE STRENGTH = 250 ksi)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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convenient. consistent. correct.

## PACKING SLIP

20817

#2, 6104 - 82 Ave  
Edmonton, AB T6B 0E7  
t + 780 442 4020  
f + 780 466 8000

BILL TO:

Dart Aerospace Ltd.  
1270 Aberdeen St.  
Hawkesbury ON K6A 1K7

SHIP TO:

DATE		ORDER No.		SHIP VIA	
5-Jul-10		PO12149		Fedex 151793240	
QUANTITY	DESCRIPTION			UNIT	AMOUNT
10	D3260-IP Spring				
S. 0607107					
GST #	TERMS	SUBTOTAL	FREIGHT	GST	TOTAL
854454527	NET 30 DAYS				



## MATERIAL CERTIFICATION

REPORT FOR: Dart Aerospace Ltd.	DATE: 7/5/2010
PART/DRAWING #: <u>D32601P</u>	PO # 8786
SPRING DESCRIPTION: Torsion Spring	QUANTITY: <u>10</u>
MATERIAL GRADE: T302 Stainless Steel Wire Spring ASTM-313-03 <i>Schultz</i>	

### PROPERTIES:

#### Chemical

Carbon:	(C)	0.071
Chromium:	(Cr)	18.380
Copper:	(Cu)	0.480
Manganese:	(Mn)	1.380
Molybdenum:	(Mo)	0.360
Nickel:	(Ni)	8.150
Nitrogen:	(N)	0.070
Phosphorus:	(P)	0.029
Silicon:	(Si)	0.420
Sulphur:	(S)	0.001

#### Physical

Size: 0.041"  
Tensile: 291,000 / 285,000  
Hardness: N/A

Heat # 41249

Certified by: Jeremy Burrows

Victory Spring Ltd. certifies this to be a true & accurate copy of the original  
contained in the company records.

## CERTIFICATE OF CONFORMANCE

REPORT FOR : Dart Aerospace Ltd.	DATE: 7/5/2010
PART/DRAWING #: <u>D32601P</u> <i>Solex</i>	PO # 8786
SPRING DESCRIPTION: Torsion Spring	QUANTITY: 10

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	<u>SS 302</u>	<u>yes</u>	
Material diameter	0.040"	<u>0.041"</u>	
Coil I.D.			
Coil O.D.	0.200"	0.202"	
Number of Coils	12	12	
Free Length	0.480" ref.	0.474"	
Helix	LHW	yes	
End type	legs as per dwg.	yes	

### COMMENTS

Mill-Certificate attached: yes  
Material Heat Number: 41249

Inspected by: *Jeremy Burrows*